

FIG 1

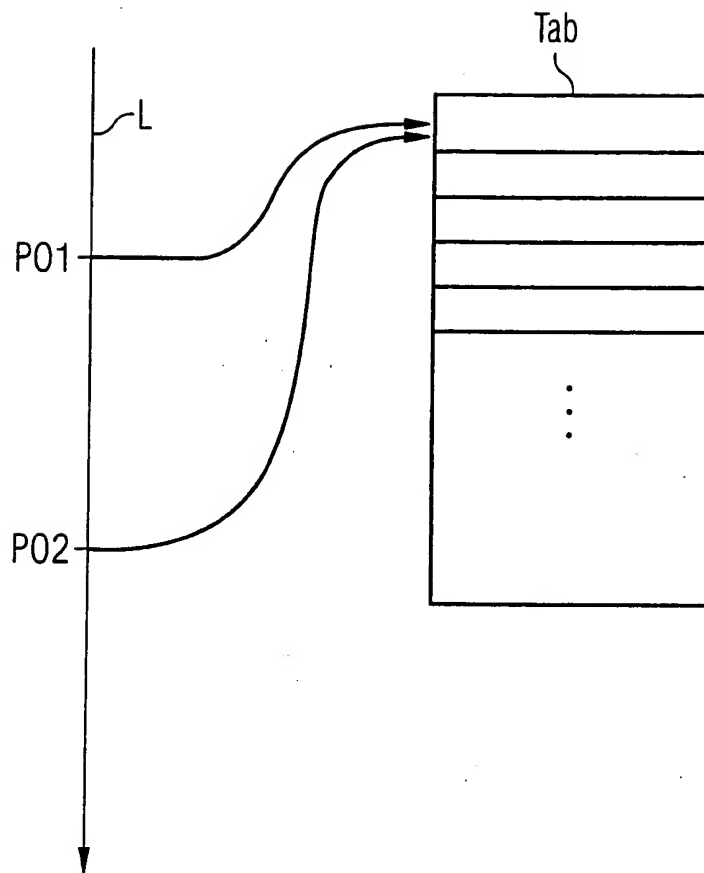


FIG 2

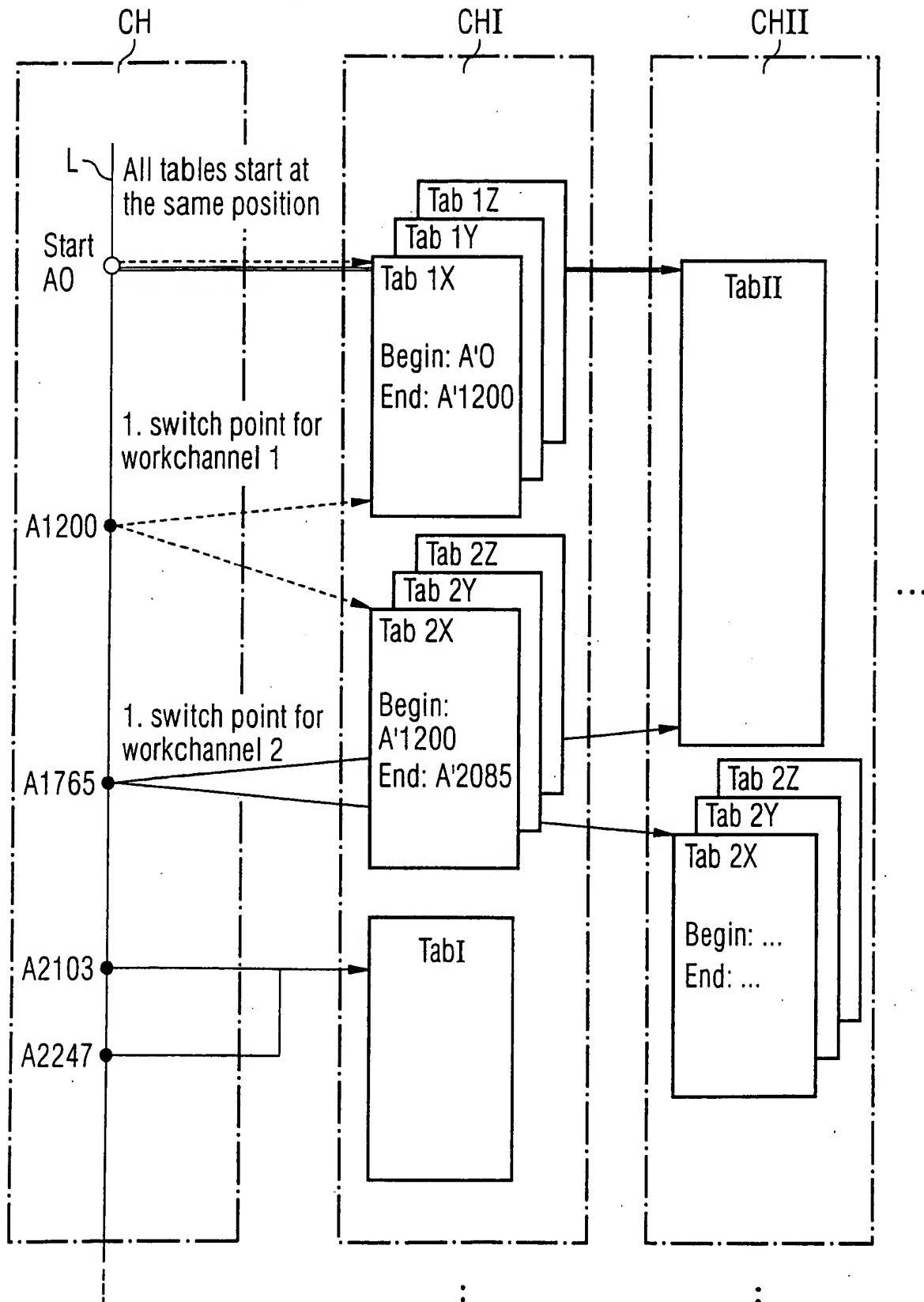
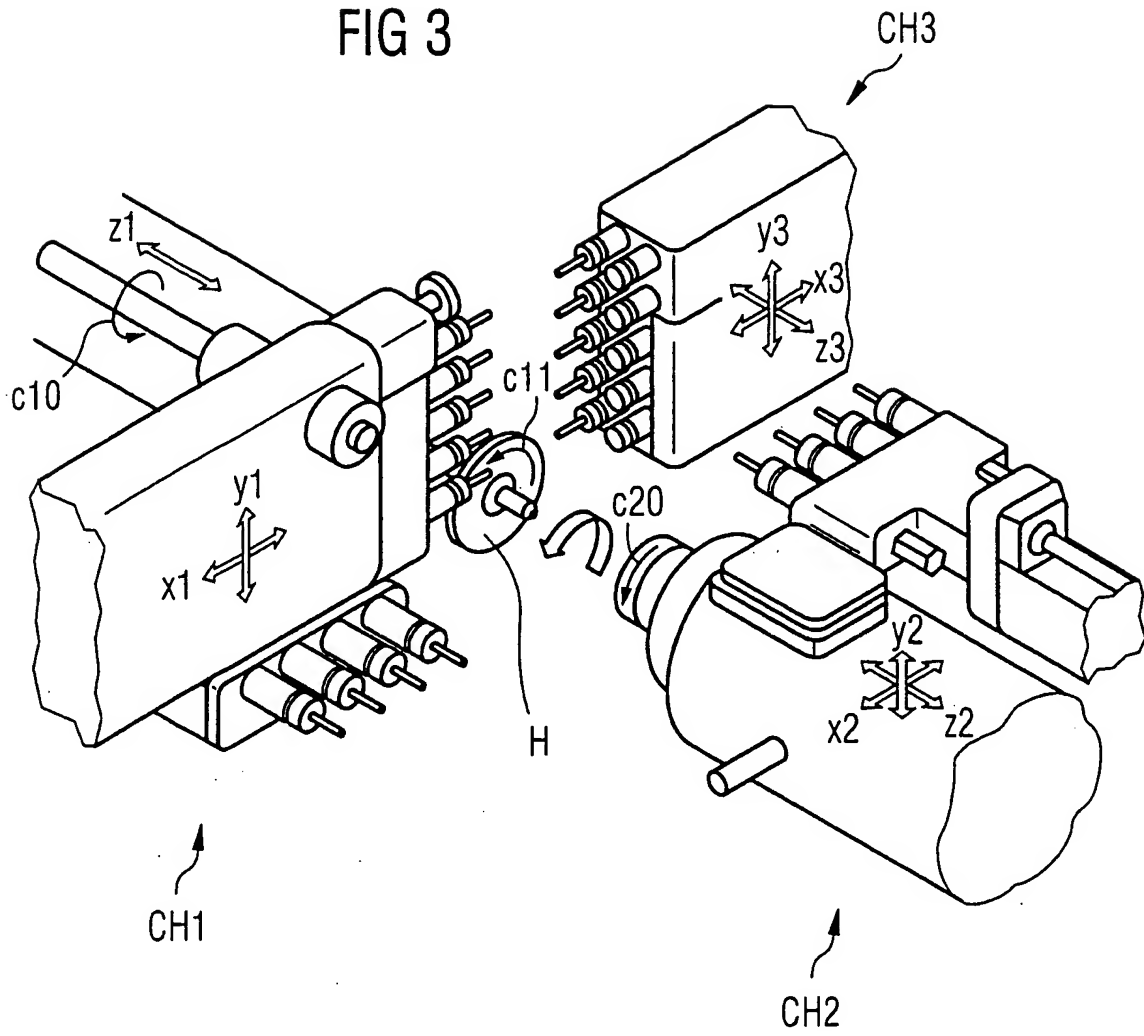


FIG 3



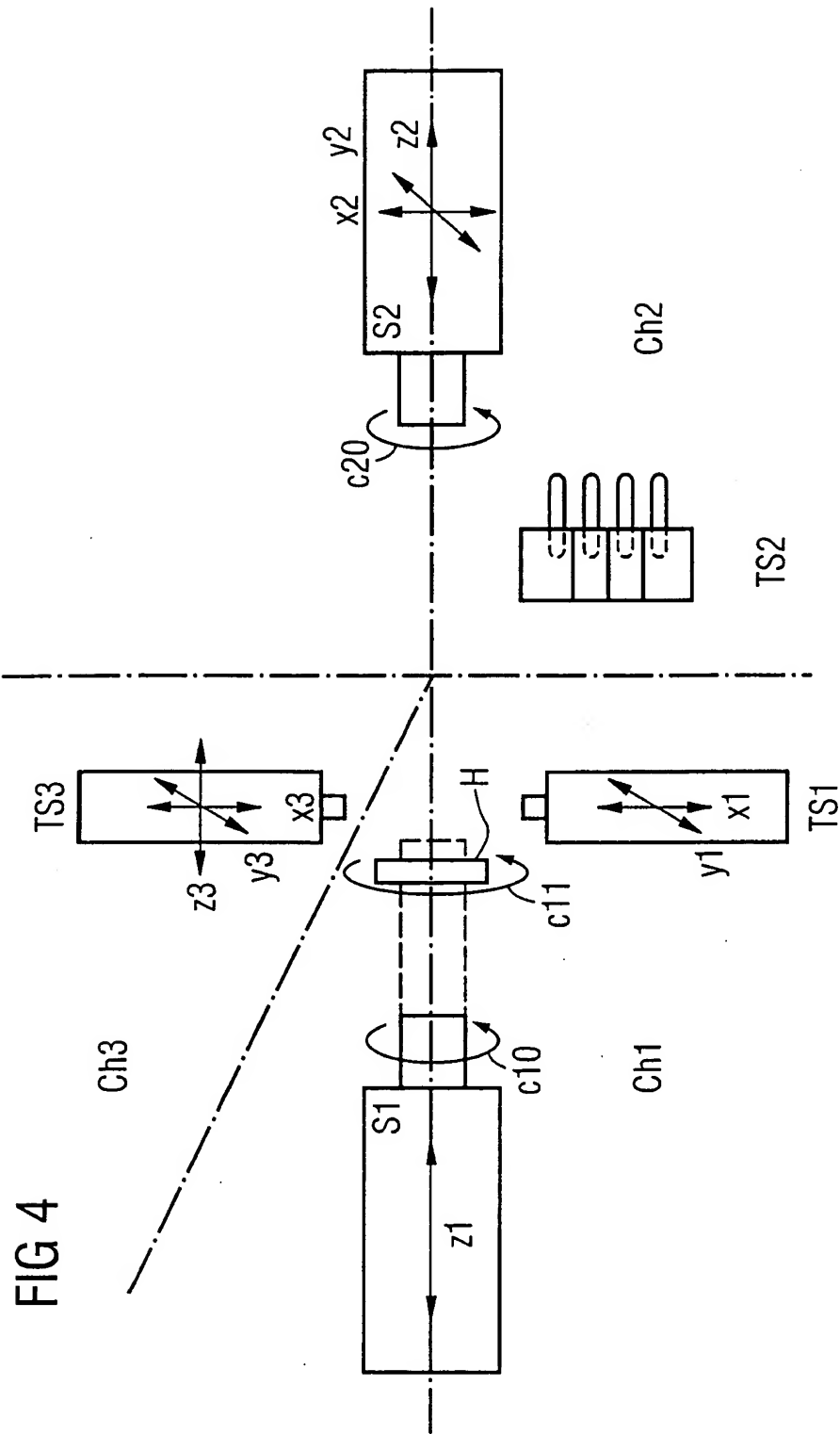


FIG 5

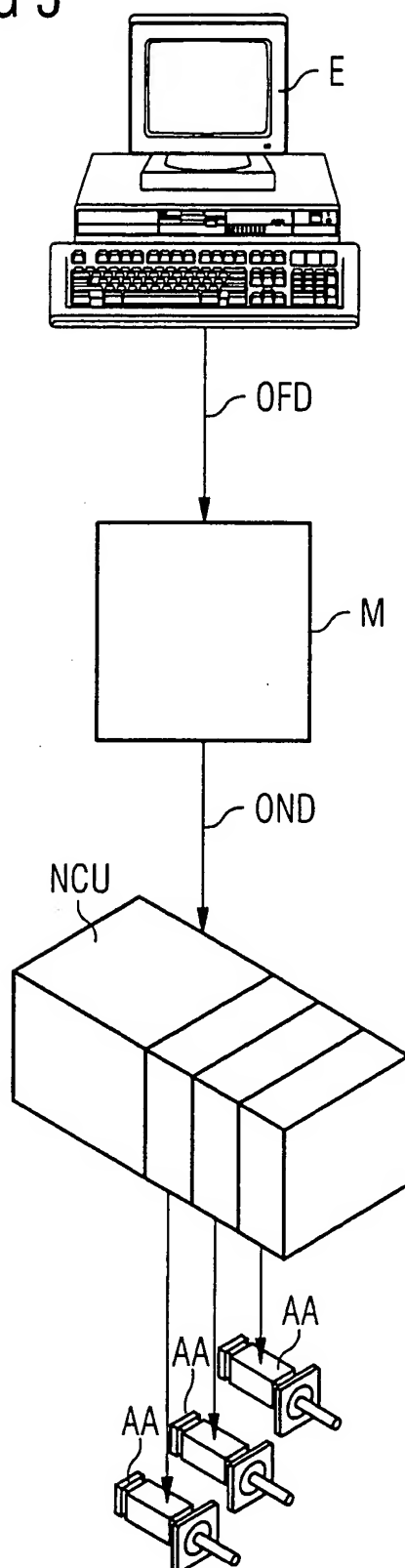


FIG 6

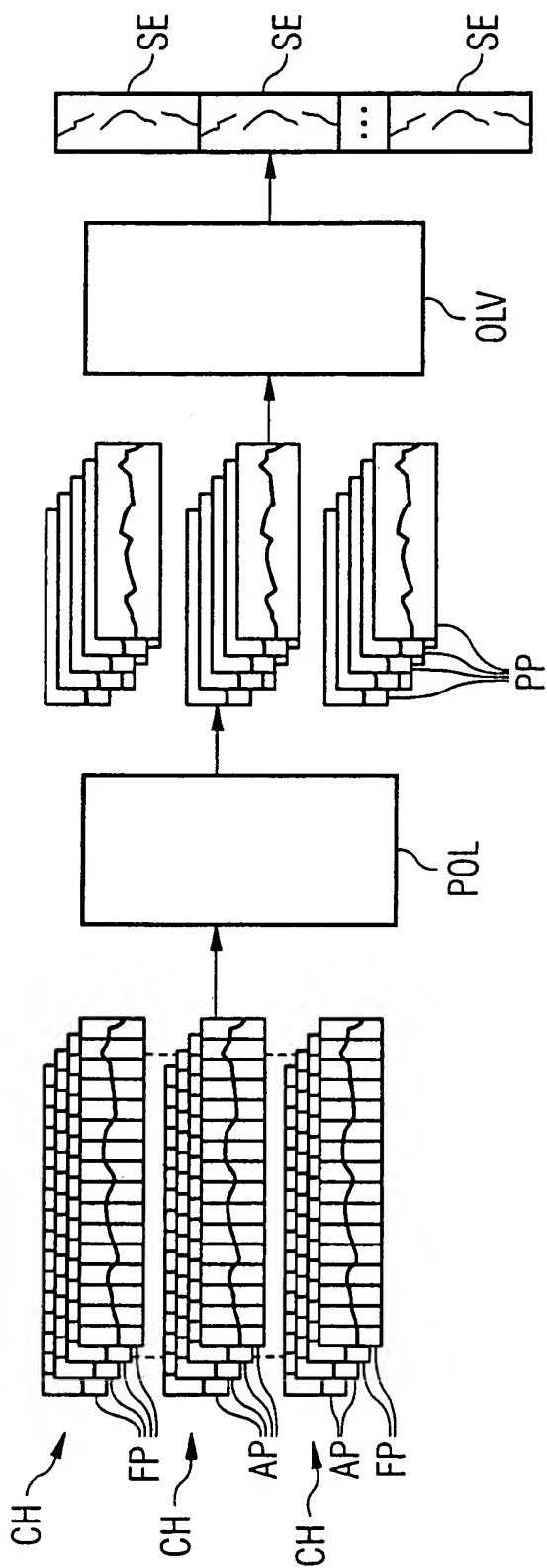


FIG 7

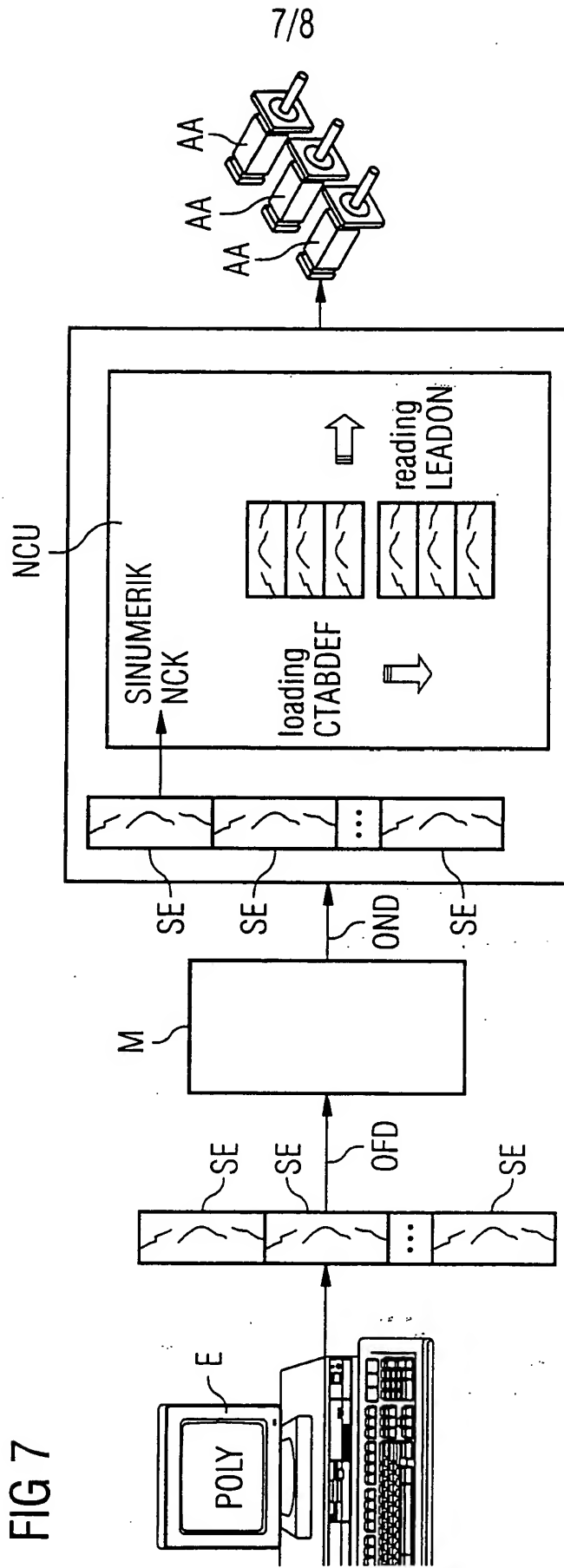


FIG 8

lead value	speed/ position	M function
1. Table		
A0	S1200	M1 = 4
A140	S2400	M1 = 4
A190	S0	M1 = 5
A250	S270	M1 = 19
A300	S3000	M1 = 3
A330	S0	M1 = 5
2. Table		
A330	S0	M1 = 5
A440	S270.5	M1 = 19
A700	S4500	M1 = 3
A900	S3000	M1 = 3
A1100	S0	M1 = 19
A1330	S0	M1 = 5

AI

AII

AII

AI

AII

